







Date: Monday, 9/11/2006 3:43:13 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 28478	
Estimate Number : 12411	
P.O. Number : N/A	Part Number : D35011
This Issue : 9/11/2006 S.O. No. : N/A	Drawing Number : D3501 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 28127	Material : N/A
Written By : <u>                    </u>	Due Date : 9/30/2006
Checked & Approved By : <u>                    </u>	Qty: <u>220</u> Um: Each
Comment : Est Rev:A New Issue 06-05-09 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M303R0750 303 Round Bar .75"
	
Comment: Qty.: 0.0831 f(s)/Unit Total : <u>16.6110</u> f(s) 303 Round Bar .75" <u>18.3</u> (M303R0750) Batch: <u>M102318</u> <u>06/10/12</u>	
2.0	HARDINGE HARDINGE CNC LATHE SMALL
	
Comment: 1-TURN AS PER FOLIO FA650 & DWG D3501 , FOLIO REV: <u>A</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED <u>06/10/12</u> <u>220</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>06/10/12</u> <u>220</u>	
4.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>06.10.13</u> <u>220</u>	
5.0	PACKAGING 1 PACKAGING RESOURCE #1
	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST 446</u> <u>06/10/13</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DE Date: 06/10/16

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28478

Part Number: D35011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



228

Comment: FINAL INSPECTION/W/O RELEASE

06/10/16

Job Completion



U 06/10-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

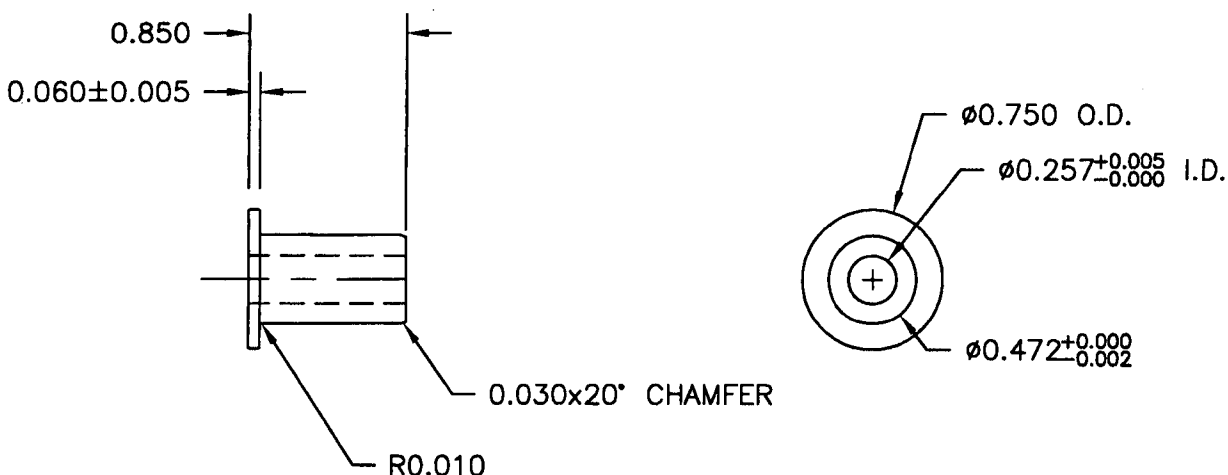
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3501	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE BUSHING	SCALE 1:1
A	06.04.18	NEW ISSUE	



### D3501-1 BUSHING

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
**RELEASED**  
NO 28478  
WITHOUT NOTICE

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DART AEROSPACE LTD		Work Order: 28478
Description: <del>Crosstube Assembly</del> Bushing		Part Number: D3501-1
Inspection Dwg: D3501	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.750	±.010	.750	✓			
	.472	+ .000 - .002	.472	✓			
	.257	+ .005 - .000	.260	✓			
	.850	±.010	.849	✓			
	.060	± .005	.059	✓			
	.030 x 20°	±.010	.030 x 20°	✓			
SIDE B							

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 06/10/12	Date: 06/10/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	